

Work Order ID 133077

Tuesday, May 26, 2015 8:52:27 AM

133077

Page 1

Item ID: D4212-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 429 Clamp Cushion

Start Date: 5/26/15 Start Qty: 40.00

40

Cust Item ID:

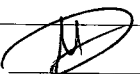
Required Date: 6/05/15 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: 

Date: 5.5.26

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4212

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Turn as per folio FA974 & dwg

FOLIO REV: N-ADWG REV: 0

2-Deburr as required

40 0 J.C.L. 15/06/01

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

40 0 J.C.L. 15/06/01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Page 2

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Revision ID: Stop ***NS2***
Item Name: 429 Clamp Cushion
Start Date: 5/26/15 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 6/05/15 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				40	6		DAS 37 9-89 15.06.01
Quality Control									
130	Identify as per dwg & Stock Location: <u>ST545</u>	0.00							
130									
Packaging	Memo	0.00				40x			DAS 28 9-89 JUN 02 2015
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									15/6/2015 MF 15-6-02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, May 26, 2015 8:57:50 AM

Page 1

Work Order ID: 133077

133077

Parent Item: D4212-1

D4212-1

Parent Item Name: 429 Clamp Cushion

Start Date: 5/26/15

Required Date: 6/05/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-09-29 JLM VERIFIED BY:DD IPP
REV:B 11.01.10 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No			100	f	52.1750	0.3708	16			

D4287-1

Uhmw U-Channel

Location

Loc Qty

Loc Code

ST479a

52.175

131542

52.175

15.66/5' J.C.L. 15/05/27

DQA: _____ Date: _____

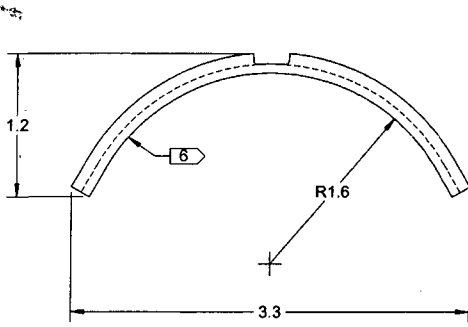


WORK ORDER NON-CONFORMANCE / UPDATE

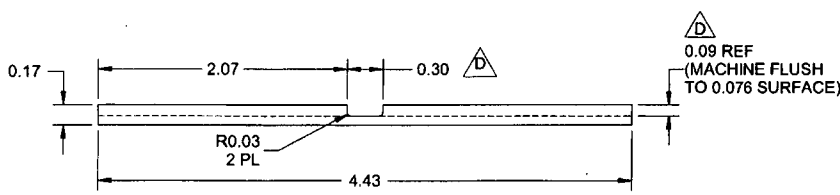
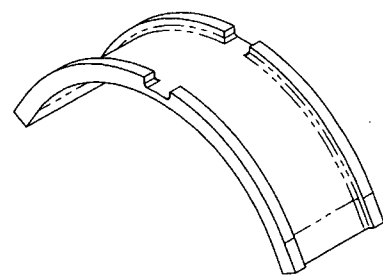
QA Closed: _____ Date: _____

Work Order update only ☐

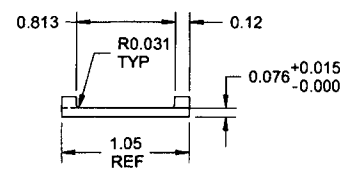
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D4212-1 CLAMP CUSHION
(MAKE FROM D4212-1F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)



D4212-1F FLAT MACHINED STATE



RELEASED
2015 MAY 22
A.R. ECN 15-567

- NOTES:**
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4212-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

15.5.26

D	ADD RETENTION SLOT, ADD COLD FORM NOTE, REFERENCE DIMENSIONS IN D4212-1 REASON: PAR 14-331, NCR 14-3521	VS	15.04.24
C	ADDED FLAT MACHINED STATE, CHANGED DIMENSIONS IAW MANUFACTURING PROCESS. REF: PAR10-29	MB	10.12.07
B	REDESIGN TO REDUCE COST: "CLAMP CUSHION" WAS "429 CLAMP CUSHION", MATL WAS MUHMMWTR3.500W.XXXW (ZN A7-1)	MB	10.10.26
A	NEW ISSUE	MB	10.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4212	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	15.04.24	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED